

**Work Order ID 53094**

October 22, 2009 3:55:02 PM



Page 1

Item ID: D3940-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Floor Protector (407)

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: RPDate: 09-10-29 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

2.

BB  
09/10/27

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA042 using tool DT9502  
Dwg Rev: A  
Folio Rev: A

BB  
09/10/27  
X2

**Work Order ID 53094**

October 22, 2009 3:55:02 PM

Page 2

Item ID: D3940-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Floor Protector (407)

Start Date: 21/10/2009 Start Qty: 2.00

Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB  
09/10/27  
X2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

JL 09/10/27  
X2

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB  
09/10/27  
X2



October 22, 2009 3:55:02 PM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 21/10/2009      **Start Qty:** 2.00



Cast Item ID:

**Required Date: 04/11/2009    Req'd Qty: 2.00**



**Customer:**

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw**  
**Rev.**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00



QC

## Memo

0.00

### Quality Control

09/10/29 *[Signature]*

mf  
09-10-29

# Picklist Print

October 22, 2009 3:55:06 PM

Page 1

Work Order ID: 53094

Parent Item: D3940-1RevA

Parent Item Name: Floor Protector (407)

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.118-90318-08              |                        | Purchased     | No          |                     |                  | 100             | sf                 | 298.2200       | 18.0600                  |               |                |        |

Lexan Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111588

298.22

298.22

2.

309/10/27

|                              |        |              |         |
|------------------------------|--------|--------------|---------|
| DART AEROSPACE LTD           |        | Work Order:  | 53094   |
| Description: Floor Protector |        | Part Number: | D3940-1 |
| Inspection Dwg: D3940        | Rev: A | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

| Description   | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than "  | ✓      |        |                      |          |
| Shape Definition  | ✓      |        |                      |          |
| Texture Retention   | ✓      |        |                      |          |
| Material imperfections such as bumps, cracks, voids, scratching |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |
|   |        |        |                      |          |

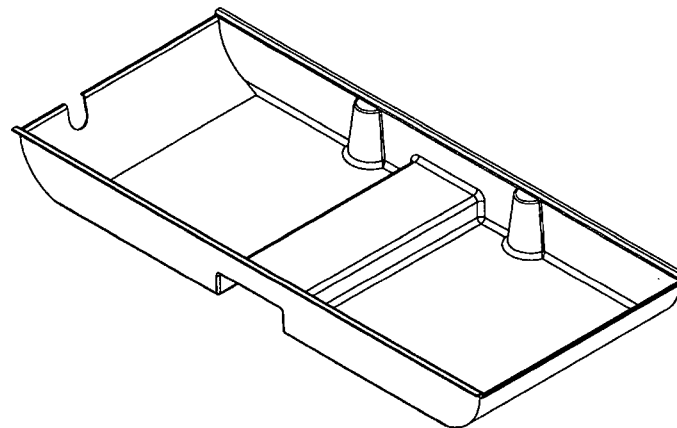
|                 |                |
|-----------------|----------------|
| Measured by: BB | Date: 09/10/27 |
|-----------------|----------------|

#### TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 45.8              | REF       | 45.5             | ✓      |        |                      |          |
| 20.8              | REF       | 20.75            | ✓      |        |                      |          |
| 0.50              | Min       | .505             | ✓      |        |                      |          |
| 0.62              | Min       | .625             | ✓      |        |                      |          |
| 0.38              | Min       | .39              | ✓      |        |                      |          |
| 0.080             | Min       | .085             | ✓      |        |                      |          |
| 0.050             | Min       | .093             | ✓      |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |
|                   |           |                  |        |        |                      |          |

|                         |                |
|-------------------------|----------------|
| Measured by: BB         | Date: 09/10/27 |
| Audited by: [Signature] | Date: 09/10/27 |
| Prototype Approval: N/A | Date: N/A      |

| Rev | Date     | Change    | Revised by     | Approved       |
|-----|----------|-----------|----------------|----------------|
| A   | 09.09.17 | New Issue | KJ [Signature] | AA [Signature] |



WUS3094

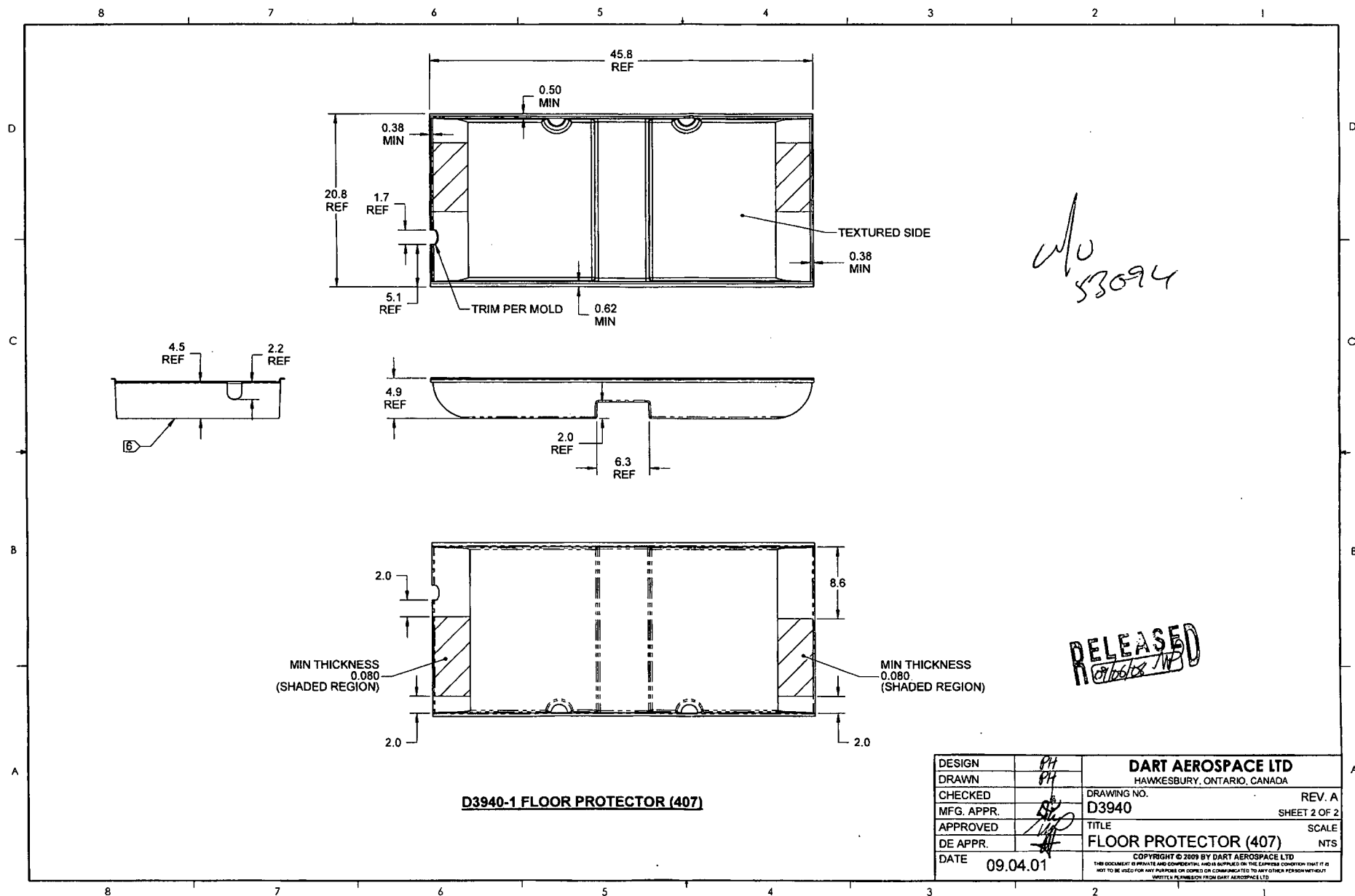
**D3940-1 FLOOR PROTECTOR (407)**

**RELEASED**  
01/05/08

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

|            |             |   |              |
|------------|-------------|---|--------------|
| A          | NEW ISSUE   | PH  | 09.04.01     |
| REV.       | DESCRIPTION | BY  | DATE         |
| DESIGN     | PH          | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | PH          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | PH          | DRAWING NO.   | REV. A       |
| MFG. APPR. | PH          | D3940   | SHEET 1 OF 2 |
| APPROVED   | PH          | TITLE   | SCALE        |
| DE APPR.   | PH          | FLOOR PROTECTOR (407)   | NTS          |
| DATE       | 09.04.01    | COPYRIGHT © 2003 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD |              |



|            |          |  |           |
|------------|----------|--|-----------|
| DESIGN     | PH       | <b>DART AEROSPACE LTD</b>  |           |
| DRAWN      | PH       | HAWKESBURY, ONTARIO, CANADA  |           |
| CHECKED    | PH       | DRAWING NO. <b>D3940</b>   | REV. A    |
| MFG. APPR. | PH       | SHEET 2 OF 2   |           |
| APPROVED   | PH       | TITLE <b>FLOOR PROTECTOR (407)</b>   | SCALE NTS |
| DE APPR.   | PH       | COPYRIGHT © 2009 BY DART AEROSPACE LTD   |           |
| DATE       | 09.04.01 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |           |